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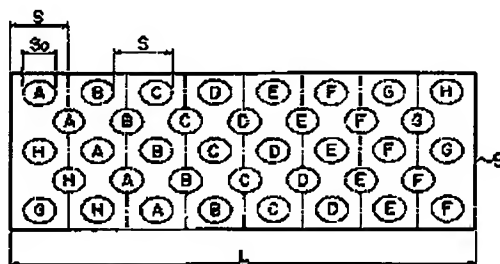
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(54) 【発明の名称】 紙おむつパッケージ品

(57) 【要約】

【目的】 紙おむつの補強シートに描かれるデザインを紙おむつごとに異なるものとする。

【構成】 補強シート用の印刷対象シートに対して、印刷進行方向における所定数でピッチ割りされた所定幅の単位領域内において、前記所定幅に収まる大きさの前記ファスニングテープの止着位置の指標となる単位デザインマークが、前記ピッチ間隔をもって前記各単位領域内にそれぞれ印刷された、単位デザインマーク列を、前記印刷進行方向と直交する方向に離間した段に複数段有し、印刷後の対象シートが前記ピッチごと分割され、この分割された前記所定数の前記補強シート群において前記単位デザインマークが前記印刷進行方向において異なり、各補強シートが紙おむつの外面シートの腹側に貼り付けられ、これらの紙おむつ群が1パッケージ内に包装されている。



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マークの組み合わせが異なり、各補強シートが紙おむつの外面シートの腹側に貼り付けられ、これらの紙おむつ群が1パッケージ内に包装されていることを特徴とする紙おむつパッケージ品も提供される。さらに、ファスニングテープ、及びこのファスニングテープが止着される外面に補強シートを有する複数の紙おむつを、1パッケージ内に包装した紙おむつパッケージ品において、前記補強シート用の印刷対象シートに対して、印刷進行方向における所定数でビッチ割りされた所定幅の単位領域内において、前記所定幅に収まる大きさの前記ファスニングテープの止着位置の指標となる単位デザインマークが、前記ビッチ間隔をもって前記各単位領域内にそれぞれ印刷され、単位デザインマーク列が形成され、前記印刷進行方向と直交する方向に離間した段において、前記所定幅に収まる大きさの前記ファスニングテープの止着位置の指標となる単位デザインマークが、前記ビッチ間隔をもって前記各単位領域内にそれぞれ印刷され、前記単位デザインマーク列とは異なる他の単位デザインマーク列が形成され、前記単位デザインマーク列は複数段有し、印刷後の対象シートが前記ビッチごと分割され、この分割された前記所定数の各補強シートには前記単位デザインマークが複数種の組み合わせで印刷されており、かつ、前記所定数の前記補強シート群において前記単位デザインマークの組み合わせそれぞれが異なり、各補強シートが紙おむつの外面シートの腹側に貼り付けられ、これらの紙おむつ群が1パッケージ内に包装されていることを特徴とする紙おむつパッケージ品の形態も提案される。すなわち、所定数の前記補強シート群において単位デザインマークが印刷進行方向において異なる形態、いずれも異なる形態、前記印刷進行方向と直交する方向において異なる形態、いずれも異なる形態、印刷進行方向及び印刷進行方向と直交する方向において異なる形態、いずれも異なる形態などが提供される。

【0006】

【作用】本発明において、補強シート上のデザインマークを印刷することにより、ファンシーな紙おむつとなり、さらに1パッケージ内の各紙おむつの補強シートに異なる複数種のデザインを施すことにより、バラエティに富むものとなる。しかも、番号マークの他、漫画やイラストが描かれる単位デザインマークを印刷し、ファスニングテープの止着位置の指標とし、その止着位置の指標デザイン自体が異なることで、装着者にとって興味のあるものとなる。そして特に、複数種の単位デザインマーク列によって形成される、各補強シートにおいて、単位デザインマークが複数種の組み合わせで印刷されており、かつ、所定数の補強シート群において前記単位デザインマークの組み合わせが異なる、特にいずれも異なるようにすることで、よりバラエティに富むものとなる。しかも、止着位置の指標デザイン自体が所定数の補強シート（紙おむつ）単位でそれぞれ異なるようにすること

で、装着者にとってより興味のあるものとなる。

【0007】また、単位デザインマークは、ビッチ割りされた所定幅の単位領域内において、前記所定幅に収まる大きさのものであるから、ファスニングテープの止着位置の指標として明確に認識できるものとなる。

【0008】

【実施例】以下、本発明を実施例に基づき詳説する。図4に示されるように、紙おむつ1は、その装着に当たっては、紙おむつ1をU字状にして着用者の身体に当てがった後、紙おむつ1の背側両端に設けられたファスニングテープ2、2を着用者の腰側まで持ち込み、腰側の外面シート上に貼付された補強シート3に対して止着する。前記補強シート3としては、表面に離型剤を施した紙、あるいはプラスチックシート等を使用することができるが、一般的にはプラスチックシートが最も多く使われている。最も多く使用されているプラスチックシートを例に取って説明すると、プラスチック上への印刷方法としては、図3に示されるグラビア印刷法が一貫的に採用される。グラビア印刷は凸版、オフセット印刷には使用することのできない有機溶剤の入った印刷インキを使用することができるため、プラスチックへの印刷に際して好適に用いられる。なお、フレキソ印刷、スクリーン印刷などを採用することもできる。

【0009】ここで、図3に基づき、グラビア印刷について簡単に説明すると、インキ容器7内のグラビアインキ8の一部を浸漬する版シリンダ6と、この版シリンダ6と接触して回転する加圧シリンダ5とが設けられ、この接触部分に接印刷物たるプラスチックシート3（補強シート3の切断前のストリップ状態）が供給されるとともに、前記版シリンダ6の表面に転移したグラビアインキ8がドクターブレード4により掻き取られながら前記接触部分まで移送され、この接触部分において両シリンダ5、6によって押圧されてプラスチック面に印刷が行われる。なお、多色刷りの場合は、前記印刷部を並設するとともに、その間に乾燥部を備えて、1パスによって多色刷りが行われる。

【0010】グラビア印刷においては、印画の製版原稿から複写によりネガを作り、ネガから適当な方法によって透明ポジを作る。一方、版シリンダの腐食を行う媒体として使用されるカーボンチッシュに対して感光化処理（センシタイズ）を行い、このチッシュにグラビア用スクリンの焼き付けを行う。そして、このチッシュに前記透明ポジを焼き付けた後、前記版シリンダ6に巻付けて乾写を行う。その後、現像→塗込み→腐食→検版→クロムメッキ処理を行い、この版シリンダ6を用いて図3に示される方法により印刷が行われる。

【0011】本発明の補強シートを得る際における印刷に際しては、印刷デザインの基となる製版原稿の製作において、図1に示されるように、製版原稿9の長手方向に補強シート3の幅Sを1区分としてI～VIIIにビッチ

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割りを行う。仮に、ここで補強シート3の幅Sを45mmとすると製版原稿9の長さLは360mmとなる。I～VIIIにピッチ割りされた各区画領域においては、それぞれ両側部分に10～15mm程度の未印刷部分を設けて、各区画領域a～hにそれぞれ異なるデザインを描かれる。前記未印刷部分を設けるのは、隣接する相互に異なるデザインの境界線からカット線がずれた場合を考慮したためであり、好ましくは各区画領域I～VIIIの境界線部分に光電管マークを同時に印刷し、光電管によりカット位置を検出して該所定位置でプラスチックシートをカットする。

【0012】また、本発明に係る印刷方法として、図2に示されるように、製版原稿9の長手方向長さLを補強シートの幅S長さで分割する分割数、すなわち $L/S = 360/45 = 8$ 個のA～Hの単位デザインマークを点在状に配列する。なお、ここで使用するデザインマークの最大寸法S<sub>0</sub>は、大き過ぎると補強シート幅S内に収まらず、また周囲のデザインマークとの配置バランスを考慮して前記補強シート幅Sの $1/3 \sim 2/3$ とする。また、その配列方法は、前記A～Hの各デザインマークを製版原稿の長手方向に実質的に前記補強シート幅Sの離隔Sをもって整列状態に、かつ複数段で配列するとともに、隣接する上下段とは製版原稿9の長手方向に補強シート幅Sの $1/3 \sim 2/3$ のズレをもって配列される。したがって、本方法に従って印刷された図2のプラスチックシートはどこでカットしても、それぞれ異なるデザインの補強シートとなる。

【0013】以上の方法によって、複数種のデザインが\*

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\*描かれた補強シート3を紙おむつに使用することによって、1パッケージ内に梱包される各紙おむつごとに、そのデザインを楽しむことができるようになる。

【0014】

【発明の効果】以上詳説のとおり、本発明によれば、補強シート上のデザインマークを印刷することにより、ファンシーな紙おむつとなり、さらに1パッケージ内の各紙おむつの補強シートに異なる複数種のデザインを施すことにより、バラエティに富み、しかも、単位デザインマークを形成してファスニングテープの止着位置の指標とし、その止着位置の指標デザイン自体が異なることで、装着者にとって興味のあるものとなる。また、単位デザインマークは、ピッチ割りされた所定幅の単位領域内において、前記所定幅に収まる大きさのものであるから、ファスニングテープの止着位置の指標として明確に認識できるものとなる。

【図面の簡単な説明】

【図1】製版原稿の展開図である。

【図2】他例による製版原稿の展開図である。

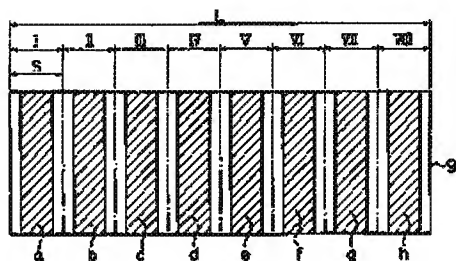
【図3】グラビア印刷法の概略説明図である。

【図4】紙おむつの装着状態図である。

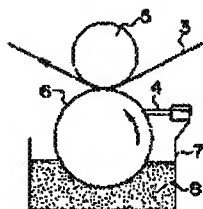
【符号の説明】

1…紙おむつ、2…ファスニングテープ、3…補強シート、4…ドクターブレード、5…加圧シリンダ、6…版シリンダ、7…インキ容器、8…グラビアインキ、9…製版原稿、I～VIII…区画領域、A～H…単位デザインマーク

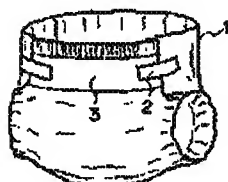
【図1】



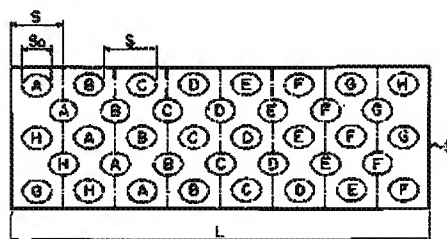
【図3】



【図4】



【図2】



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PAPER DIAPER PACKAGE PRODUCT

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[There are no amendments to this patent.]

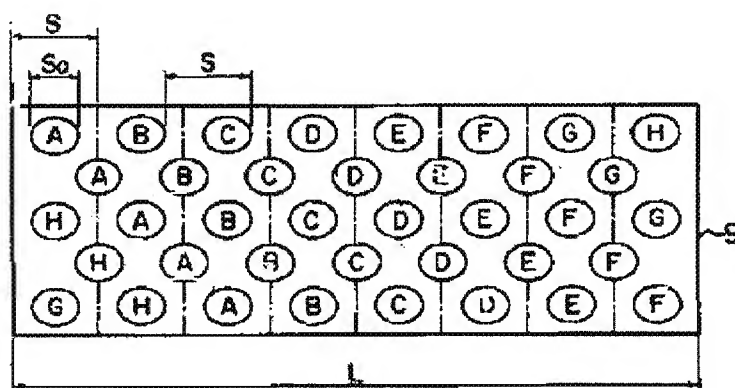
## Abstract

### Objective

For the design depicted on the reinforcing sheet of a paper diaper to be different for each paper diaper.

### Constitution

With respect to a sheet to be printed for the aforementioned reinforcing sheet, there being unit regions of predetermined width pitch divided by a predetermined number in the printing direction; unit design marks, which indicate the position for immovable attachment of the aforementioned fastening tape of a size that fits within the aforementioned predetermined width, are printed respectively in each of the aforementioned unit regions, with the aforementioned pitch interval; a unit design mark row has multiple ranks separated at intervals in a direction perpendicular to the aforementioned printing direction; after printing, the object sheet is divided for each of the aforementioned pitches; the aforementioned unit design marks differ along the aforementioned printing direction in the aforementioned reinforcing sheet group [that had resulted from the original undivided reinforcing sheet] being divided into the aforementioned predetermined number [of divisions], each reinforcing sheet is fixed on the stomach side of the outside sheet of a paper diaper, and a group of these paper diapers is packaged into 1 package.



## Claim

A paper diaper package product, being multiple paper diapers having a fastening tape and a reinforcing sheet on the outer surface to which said fastening tape is immovably attached, packaged within a single package, characterized by the following facts:

With respect to a sheet to be printed for the aforementioned reinforcing sheet, there being unit regions of predetermined width pitch divided by a predetermined number in the printing direction; unit design marks, which indicate the position for immovable attachment of the

aforementioned fastening tape of a size that fits within the aforementioned predetermined width, are printed respectively in each of the aforementioned unit regions with the aforementioned pitch interval; a unit design mark row has multiple ranks in ranks separated at intervals in a direction perpendicular to the aforementioned printing direction; after printing, the object sheet is divided for each of the aforementioned pitches; the aforementioned unit design marks differ along the aforementioned printing direction in the aforementioned reinforcing sheet group [that had resulted from the original undivided reinforcing sheet] being divided into the aforementioned predetermined number [of divisions], each reinforcing sheet is fixed on the stomach side of the outside sheet of a paper diaper, and a group of these paper diapers is packaged into 1 package.

#### Detailed explanation of the invention

[0001]

##### Technical Field of the Invention

The present invention pertains to a paper diaper package product that has a reinforcing sheet in order to immovably attach a fastening tape of a paper diaper.

[0002]

##### Prior art

Recently, the paper diapers generally available have an absorbent body interposed between a liquid-impermeable outside sheet and a liquid-permeable inside sheet, and a fastening tape for fastening the paper diaper to both edges of the back side. Regarding the fastening of the paper diaper, it is rather difficult to fasten it in one try in a trim and satisfactory condition, and actually numerous attempts at immovable attachment are needed. Nevertheless relatively thin plastic material, such as thin polyethylene sheets, are often used for the aforementioned outside sheet; once fastening tape is attached to the outside sheet, the fastening tape is difficult to remove without breaking the outside sheet, so a reinforcing sheet comprising a plastic material is fixed on the abdominal side of the outside sheet to make repeated attempts at immovably attaching [the fastening tape] possible.

[0003]

##### Problems to be solved by the invention

Generally, paper diapers are sometimes sold as single articles, but normally paper diapers are sold [in sets] of 36 or 72 as 1 package; with regard to the aforementioned reinforcing sheet that is fixed on each paper diaper, the design illustration printed on all of the paper diapers is the same. For an infant using a paper diaper, the depicted design is one point of interest, but the effort of printing a design is gone to waste if the infant loses interest because all the designs are



the same. If different designs could be provided to each paper diaper removed from the package, [the infant] would show interest towards that design each time [a paper diaper] is taken out, and find pleasure in the respectively depicted designs.

[0004]

The main object of the present design invention is to offer a paper diaper package product for which the print design of the paper diaper reinforcing sheet is skillfully designed, such that printing design marks on the reinforcing sheet resembles fancy paper diapers, and in imparting multiple types of designs that are different for each paper diaper in 1 package, a wealth of variety [is offered]; furthermore a unit design mark is formed as an indicator of the position for immovable attachment of the fastening tape, and the immovable attachment indicator design itself is different, which is fascinating to the wearer.

[0005]

Means to solve the problems

In order to solve the aforementioned problems, the present invention pertains to a paper diaper package product wherein multiple paper diapers having fastening tape and a reinforcing sheet on the outer surface to which this fastening tape is immovably attached are packaged within a single package. The present invention further offers a paper diaper package product, being a paper diaper package product of multiple paper diapers having fastening tape and a reinforcing sheet on the outer surface to which this fastening tape is immovably attached, packaged within a single package, characterized by the following facts: that with respect to a sheet to be printed for the aforementioned reinforcing sheet, there are unit regions of predetermined width pitch divided by a predetermined number in the printing direction; unit design marks, which indicate the position for immovable attachment of the aforementioned fastening tape of a size that fits within the aforementioned predetermined width, are printed respectively in each of the aforementioned unit regions, with the aforementioned pitch interval; a unit design mark row has multiple ranks in ranks separated at intervals in a direction perpendicular to the aforementioned printing direction; after printing, the object sheet is divided for each of the aforementioned pitches; the aforementioned unit design marks differ along the aforementioned printing direction in the aforementioned reinforcing sheet group [that had resulted from the original undivided reinforcing sheet] being divided into the aforementioned predetermined number [of divisions], each reinforcing sheet is fixed on the stomach side of the outside sheet of a paper diaper, and a group of these paper diapers is packaged into 1 package. A mode for a paper diaper package product is also proposed in which a paper diaper package product, being a paper diaper package product of multiple paper diapers having fastening tape

and a reinforcing sheet on the outer surface to which this fastening tape is immovably attached, packaged within a single package, is characterized by the following facts: a unit design mark indicating the position for immovably attaching the aforementioned fastening tape of a size that fits within the aforementioned predetermined width is printed within each respective aforementioned unit region, with the aforementioned pitch spacing intervals; a unit design mark row is formed; in a spaced rank along a direction perpendicular to the aforementioned printing direction, a unit design mark indicating the position for immovably attaching the aforementioned fastening tape of a size that fits within the aforementioned predetermined width is printed respectively within an aforementioned respective unit region, with the aforementioned pitch spacing intervals; another unit design mark row is formed differing from the aforementioned unit design mark row; the aforementioned unit design mark row has multiple ranks; after printing, the object sheet is divided for each aforementioned pitch; each reinforcing sheet of the aforementioned predetermined number that has been divided is printed by a combination of multiple types of the aforementioned unit design marks; and the aforementioned combinations of unit design marks differ respectively in a group of the aforementioned predetermined number of the aforementioned reinforcing sheets; each reinforcing sheet is fixed on the stomach side of the outside sheet of a paper diaper; and these paper diaper groups are packaged into 1 package. In other words, for a group of a predetermined number of the aforementioned reinforcing sheets, [the present invention] offers different configurations of unit design marks in the printing direction, different configurations in the direction perpendicular to the aforementioned printing direction, different configurations in the printing direction and the direction perpendicular to the printing direction, and the like.

[0006]

#### Operation

The present invention provides a wealth of variety by printing design marks on a reinforcing sheet, having this resemble fancy paper diapers, and imparting multiple types of designs that are different for each paper diaper in 1 package. It is also fascinating to the wearer, because in addition to numbers, unit design marks are printed which depict cartoons or illustrations, as indicators of the position for immovable attachment of the fastening tape, and the immovable attachment position indication design itself is different. In particular, each reinforcing sheet, formed by multiple ranks of unit design mark rows, has a wealth of variety, being printed with multiple combinations or unit design marks, and within a group of a predetermined number of reinforcing sheets, the aforementioned unit design mark combinations also differs, so each one is quite different. It is also fascinating to the wearer, because the designs

themselves for indicating the position for immovable attachment each differ for each unit of the predetermined number of reinforcing sheets (paper diapers).

[0007]

A unit design mark has a size that fits in the aforementioned predetermined width, within a unit region of predetermined width of divided pitch, thus enabling clear determination as an indication of the fastening tape immovable attachment position.

[0008]

#### Application examples

The present invention is explained in detail below, based on application examples. As shown in Figure 4, with regard to the wearing of paper diaper 1, the paper diaper 1 is made into a U-shape and then placed on the wearer's body. Subsequently, the fastening tapes 2 and 2 furnished on both edges of the back side of paper diaper 1 are brought around to the wearer's stomach side, and immovably attached against reinforcing sheet 3 fixed on the outside sheet of the stomach side. It is possible to use, as the aforementioned reinforcing sheet 3, a plastic sheet or paper treated on the surface with a mold release agent, but generally a plastic sheet is most commonly used. In terms of an example for a plastic sheet, this being the most commonly used, generally gravure printing shown in Figure 3 is used as the method for printing on the plastic. Gravure printing can use printing inks that contain organic solvents that cannot be used in relief printing or offset printing, so it is suitable for situations that involve printing onto plastics. It is also possible to use flexographic printing and screen printing.

[0009]

Here, gravure printing is explained simply based on Figure 3. A printing cylinder 6 is partly immersed in gravure ink 8 within ink container 7, and a pressure cylinder 5 that comes into contact with printing cylinder 6 and rotates are provided. When a plastic sheet 3 (the reinforcing sheet 3 in a strip prior to being cut into sections) is supplied to a contact portion, the gravure ink 8 that has been transferred onto the aforementioned printing cylinder 6 is sent to the aforementioned contact portion while being scraped away by doctor blade 4, and is pressed by both cylinders 5 and 6, effecting the printing onto the plastic surface, while a dry sector is furnished between them, and multicolor printing is effected in 1 pass.

[0010]

In gravure printing, a negative is prepared by duplication from a print-ready original, and a transparent positive is prepared by a suitable method from a negative. Separately, a

photosensitization treatment (sensitization) is conducted on the carbon tissue that is used as a medium that carries out corrosion of a printing cylinder, and the screen for gravure is burned onto this tissue. Then after the aforementioned transparent positive is burned onto this tissue, it is wrapped against the aforementioned printing cylinder 6 and an image is transferred.

Subsequently development --> painting into --> corrosion --> plate inspection --> chrome plating treatments are conducted and using this printing cylinder 6, printing is performed by the method shown in Figure 3.

[0011]

With regards to printing on occasions where the invented reinforcing sheet is to be obtained, in the matter of preparing a print-ready original for the basis of the printed design, as shown in Figure 1, pitch division into I-VIII is conducted, with width S of reinforcing sheet 3 as 1 sector in the longitudinal direction of print-ready original 9. For example, assume the width S of reinforcing sheet 3 is 45 mm and the length L of print-ready original 9 is 360 mm. A non-printing portion of about 10-15 mm for each side portion is provided for each pitch-divided region in I-VIII, and respectively different designs are drawn in each compartment region a through h. The [reason for] providing the aforementioned non-printing portions is in consideration of cases where cutting line joints deviate from mutually different adjacent design interface lines. Preferably, photoelectric cell marks are simultaneously printed in the interface line portion of each compartment region I through VIII, the cutting position is detected by the photoelectric cell, and the plastic sheet is cut in said predetermined location.

[0012]

As a printing method pertaining to the present invention, as shown in Figure 2, 8 individual unit design marks A through H are arrayed in dotwise fashion; [the number 8 being the] result of dividing longitudinal length L of print-ready original 9 by reinforcing sheet width S, in other words  $L/S = 360/45 = 8$ . If the maximum dimension  $S_0$  of the design mark to be used is too large, it will not fit inside the reinforcing sheet width S; in consideration of having a balanced array with the surrounding design marks, the aforementioned reinforcing sheet width S may be [set at]  $1/3$  through  $2/3$ . With regards to the array method, [in terms of lengthwise rows] the aforementioned A through H individual design marks are arrayed in multiple ranks, in an aligned condition with a clearance S of the aforementioned reinforcing sheet width S virtually in the longitudinal direction of the print-ready original; and adjacent upper and lower ranks are arranged with a  $1/3$  through  $2/3$  offset of reinforcing sheet width S along the longitudinal direction of print-ready original 9. Therefore, according to this method, regardless of where the

printed plastic sheet of Figure 2 is cut, it will form a reinforcing sheet with individually different designs.

[0013]

According to the above method, a reinforcing sheet 3 upon which multiple types of designs have been depicted is used in a paper diaper, making it possible for the designs for each paper diaper packaged within 1 package to be pleasing.

[0014]

Effect of the invention

As explained in detail above, the present invention provides that by printing design marks on a reinforcing sheet, relating this to fancy paper diapers, and imparting multiple types of designs that are different for each paper diaper in 1 package, a wealth of variety [is offered]; furthermore a unit design mark is formed, as an indicator of the position for immovable attachment of the fastening tape, and the immovable attachment indicator design itself is different, which is fascinating for the wearer. Also, the unit design mark, within a unit region of predetermined width of divided pitch, makes possible clear determination as an indication of the fastening tape immovable attachment position.

#### Brief description of the figures

Figure 1 is an expansion of a print-ready original.

Figure 2 is another example of an expansion of a print-ready original.

Figure 3 is a simplified explanatory diagram of the gravure printing method.

Figure 4 is a drawing of a condition where a paper diaper is being worn.

- |                |                      |
|----------------|----------------------|
| 1              | Paper diaper         |
| 2              | Fastening tape       |
| 3              | Reinforcing sheet    |
| 4              | Doctor blade         |
| 5              | Pressure cylinder    |
| 6              | Printing cylinder    |
| 7              | Ink container        |
| 8              | Gravure ink          |
| 9              | Print-ready original |
| I through VIII | Compartment regions  |
| A through H    | Unit design marks    |

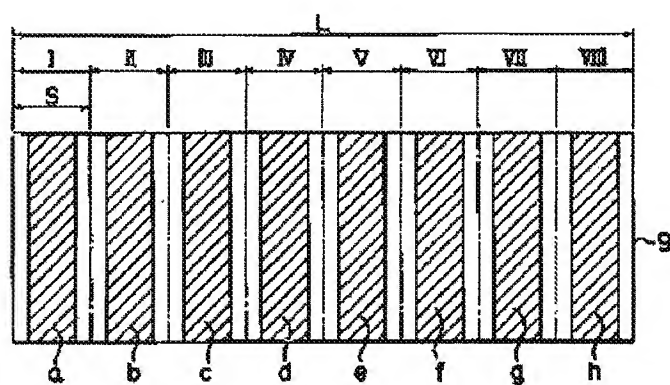


Figure 1

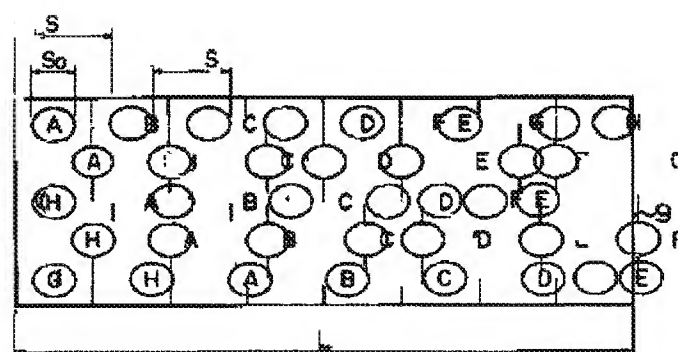


Figure 2

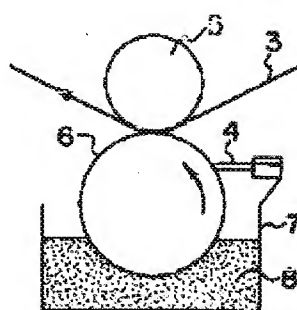


Figure 3

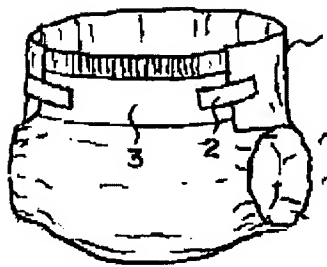


Figure 4